

Work Order ID 79015

79015

Page 1

January-18-12 1:53:11 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3274

D

100

0.00

100

DOCUMENT CONTROL

DC


Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A 

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng/ Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

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Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

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Required Date: 27/01/2012 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg - *DC 12/02/22*

D3274, cut fwd end of tube with saw table setup D3274.

REMOVE BENDING MARK *12/11-02-27*

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: *m12064* *3 BE 12/03/01*

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.

Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BB 12/03/01

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

*** 1 ***

Reference:

Run Start *NR1*

Stop ***NR2***

114 QC5- Inspect part completeness to step on W/O

0.00

0.00

51263102

0.00

0.00

812103102

0.00

0.00

3/20 12-03-02

Hand Finishing

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D206-642-541

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Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Skidtubes | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | | | | | | | | |
| | 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 | | | | | | | | |
| | 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube | | | | | | | | |
| | 3-Bond web in place as per Dwg D3274 & QSI 015. | | | | | | | | |
| | A/RSikaflex-291 | | | | | | | | |
| | Sikaflex expire date: 11/9/99 | | | | | | | | |
| | Start: 12/03/05 Time: 11:00 | | | | | | | | |
| | Finish: 12/03/09 Time: 7:00 | | | | | | | | |
| | (Adhere for 12 hours) | | | | | | | | |

DP

12-3-2

3 12/03/02

7 BB 12/03/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D206-642-541

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 170 *170* Skidtubes Skidtubes | Skidtubes Memo 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding | 0.00 0.00 | | | | | | | |

DD 12-3-5

SAD 12-03-05

BB 12/03/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D206-642-541

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 190 | | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Skidtubes | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| | 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>M120164</u> | | | | | | | | |
| | 3-Grind cross bolt welds flush as per Dwg D3274. | | | | | | | | |
| | 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr. | | | | | | | | |

4.6"
3.0"

1 0 2E 12/03/08

2E 12/03/09

SAD 12-03-12

DP 12-3-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 79015***79015***

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Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 210 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 220 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch | | | | | | | | |

IX of m-12/03/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| Powdercoat | | 0.00 | | | | | | | |
| Powder Coating | Memo START TIME: 10h55 OVEN TEMPERATURE: 320°F FINISH TIME: 11h25 | m 120 222 | | | | | | | |
| 240 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | | 0.00 | | | | | | | |
| Quality Control | Memo | | | | | | | | |
| 250 | HandFinishing | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| HandFinish | | 0.00 | | | | | | | |
| Hand Finishing | Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/RN/ALPS-3 m114317 m114596 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 m119999 Sikaflex expire date: 12/08 | | | | | | | | |

1 2 3 12/03/14

12 03 19 11

1X/1M/12/07/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 79015

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Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 18/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

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|-----------------|---|------|--|--|--|--|--|--|--|
| 260 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *260* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | Inspect Nut Plate & Inserts | | | | | | | | |

| | | | | | | | | | |
|----------------|--|------|--|--|--|--|--|--|--|
| 270 | HAND FINISHING RESOURCE #1 | 0.00 | | | | | | | |
| *270* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install wearpads & gaskets as per Dwg D3274. | | | | | | | | |

2-Install ring as per Dwg D3274
 A/RSikaflex-291 M119999
 Sikaflex expire date: 12/08
 3-Inspect for foreign objects as per QSI 024
 4-Spray inside of tube on both sides of web with LPS-3
 A/R LPS-3 Batch: N/A
 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 A/RSikaflex-291 M119999
 Sikaflex expire date: 12/08

Handwritten signature and date: 12/03/19

Handwritten signature and date: 12/03/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 79015***79015***

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Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 18/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

280 QC5- Inspect part completeness to step on W/O 0.00

280

QC

Memo

0.00

Quality Control

1 BR 123-20

290 Identify as per dwg & Stock Location: _____ 0.00

290

Packaging

Memo

0.00

Packaging

AP 79319

12/3/28

300 QC21- Final Inspection - Work Order Release 0.00

300

QC

Memo

0.00

Quality Control

12/3/29

mf 12-03-29

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-1-190

Manufactured

No

110

Each

135.0000

1

1

D2600-1-190

Extrusion Round 3" 206

**

OK 12/02/22

Location

Loc Qty

Loc Code

HALL

53

69622

53

LG

82

76912

82

D3285-1

Manufactured

No

110

Each

68.0000

1

1

D3285-1

Cap

**

BE 12/03/01

Location

Loc Qty

Loc Code

LG002

68

52511

21

52647

47

D3282-041

Manufactured

No

150

Each

7.0000

1

1

D3282-041

Float Web (206L/407)

**

1 12/03/05

Location

Loc Qty

Loc Code

LG

7

74294

7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

January-18-12 1:53:16 PM

Page 2

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

371.0000

12

12

D2649

Cross Bolt Spacer

BE 12/03/08
879504

Location

Loc Qty

Loc Code

LG

248

77574

248

LG001

123

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

76793

4

D3275-1

Manufactured No

190

Each

276.0000

12

12

D3275-1

Crossbolt Spacer

BE 12/03/08

Location

Loc Qty

Loc Code

LG002

276

66930

106

73393

118

74437

52

B

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,676.000

2

2

CR3212-4-03

Cherry Rivet

**

M-L 12/03/19

Location

Loc Qty

Loc Code

FP002

686

114859 ✓

686

ST331

990

110139

2

119017

988

2

D3415-041

Manufactured

No

250

Each

29.0000

1

1

D3415-041

Nut Plate

**

M-L 12/03/19

Location

Loc Qty

Loc Code

ST042

29

67605 ✓

29

1

CCR264SS3-3

Purchased

No

250

Each

907.0000

2

2

CCR264SS3-3

Cherry Rivet

**

M-L 12/03/19

Location

Loc Qty

Loc Code

ST331

907

113973

2

117849 ✓

137

119017

768

2

ALS4-1032-130

Purchased

No

250

Each

1,472.000

78

78

ALS4-1032-130

Insert

**

120181 M-L 12/03/20

Location

Loc Qty

Loc Code

ST280

1377

119084

1377

ST281

95

119632

95

78

January-18-12 1:53:16 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

270

Each

23.0000

1

1

D3536-15

Gasket

80333

**

M/L 12/03/20
1

Location

Loc Qty

Loc Code

FP002

23

73318

23

D3536-23

Manufactured No

270

Each

33.0000

1

1

D3536-23

Gasket

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP002

33

43406

1

73312 ✓

20

74510

12

D3536-35

Manufactured No

270

Each

32.0000

1

1

D3536-35

Gasket

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP002

32

73313 ✓

14

74511 ✓

18

D3536-39

Manufactured No

270

Each

25.0000

1

1

D3536-39

Gasket

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP002

25

73317 ✓

25

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Manufactured No

270

Each

21.0000

1

1

D3535-15

Wearshoe

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP001

21

73315 ✓

9

74512

12

D3535-35

Manufactured No

270

Each

21.0000

1

1

D3535-35

Wearshoe

**

80332

M/L 12/03/20

Location

Loc Qty

Loc Code

FP001

21

67598

1

70815

1

73311

7

74509

12

D3535-39

Manufactured No

270

Each

31.0000

1

1

D3535-39

Wearshoe

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP001

31

69759 ✓

1

73316 ✓

18

74513

12

D3535-23

Manufactured No

270

Each

34.0000

1

1

D3535-23

Wearshoe

**

M/L 12/03/20

Location

Loc Qty

Loc Code

FP001

34

73314 ✓

23

74508

11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270 Each 12.0000 1 1

D3537-3

Wearpad

Location

Loc Qty

Loc Code

FP002

12

76986

12

D3537-1 Manufactured No

270 Each 50.0000 9 9

D3537-1

Wearpad

Location

Loc Qty

Loc Code

FP002

50

69817

5

77036

45

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 80 80

*AN960C10I *

washer

AN960C416 NAS1149C0463 Purchased No

270 Each 0.0000 1 1

AN960C416

washer

D3672-1 Manufactured No

270 Each 950.0000 2 2

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FP001

308

66821 ✓

308

ST060

642

72229

142

76277

500

January-18-12 1:53:16 PM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,943.000

80

80

AN3C4A

BOLT

121060

**

80 m-l 12/03/20

Location

Loc Qty

Loc Code

ST350

2943

117313

2

117688

5

117872

10

118112

16

118451

2

118838

4

119749

904

120187

2000

AN4C5A

Purchased

No

270

Each

372.0000

1

1

AN4C5A

BOLT

**

m-l 12/03/20

Location

Loc Qty

Loc Code

FP002

19

112243

19

ST355

353

112243 ✓

253

119017

100

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 8

January-18-12 1:53:16 PM

Work Order ID: 79015

79015

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 18/01/2012

Required Date: 27/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

102.0000

1

1

D2646

Aft Cap

79562

**

1 m/d 12/03/20

Location

Loc Qty

Loc Code

FP002

102

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

84

D3413-1

Manufactured No

270

Each

35.0000

1

1

D3413-1

Ring

77940

80224

**

1 m/d 12/03/20

Location

Loc Qty

Loc Code

ST420

4

66387

3

70773

1

ST464

31

75478

31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

SHOP COPY

REF

ENG

UNCONT

SUBJECT TO ADDITIONAL

WITHOUT NOTICE

WOM

NO. 79015

RELEASED

07.02.12

DEO ATTACHED

DART

| | | | |
|-------------------------|-----------------------|---|-----------------------------------|
| DESIGN CP | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED # | APPROVED # | DRAWING NO. D3274 | REV. D SHEET 1 OF 4 |
| DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY | |
| A | | 04.03.15 | NEW ISSUE |
| B | | 04.08.09 | MOVE SADDLE HOLE: 42.14 WAS 42.76 |
| C | | 05.03.16 | ADD -043; NEW INSERTS |
| D | | 06.12.19 | NEW INSERTS, SS WEARSHOE + GASKET |

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|---------------|---|
| X | | D3274-041 | SKIDTUBE ASSEMBLY |
| | X | D3274-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2600-1-240 | EXTRUSION |
| 1 | 1 | D2646 | AFT CAP |
| 12 | 12 | D2649 | CROSS BOLT SPACER |
| 12 | 37 | D3275-1 | CROSS BOLT SPACER |
| 1 | 1 | D3282-041 | FLOAT WEB |
| 1 | 1 | D3285-1 | CAP |
| 1 | 1 | D3413-1 | RING |
| 1 | 1 | D3415-041 | NUT PLATE |
| 1 | 1 | D3535-15 | WEARSHOE |
| 1 | 1 | D3535-23 | WEARSHOE |
| 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | D3535-39 | WEARSHOE |
| 1 | 1 | D3536-15 | GASKET |
| 1 | 1 | D3536-23 | GASKET |
| 1 | 1 | D3536-35 | GASKET |
| 1 | 1 | D3536-39 | GASKET |
| 9 | 9 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-3 | WEARPAD |
| 78 | 78 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80 | 80 | AN3C4A | BOLT |
| 1 | 1 | AN4C5A | BOLT |
| 1 | 1 | AN960C416 | WASHER |
| 80 | 80 | AN960C10L | WASHER |
| 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | NAS1515H3L | WASHER |

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

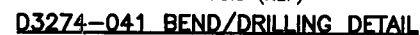
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

79015



07.02.12

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| CHECKED  | APPROVED  | DRAWING NO. D3274 | REV. D SHEET 2 OF 4 | |
| DATE 06.12.19 | TITLE SKIDTUBE ASSEMBLY | SCALE 1:15 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

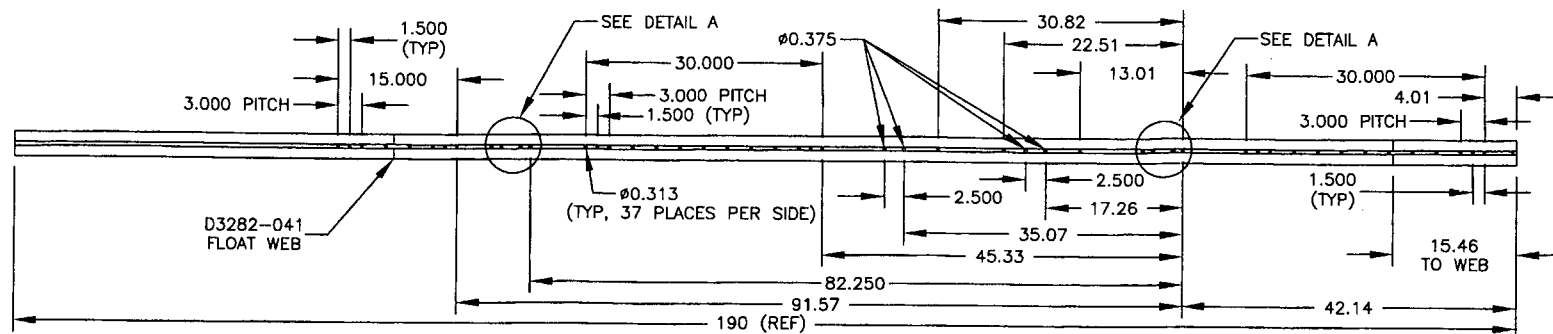
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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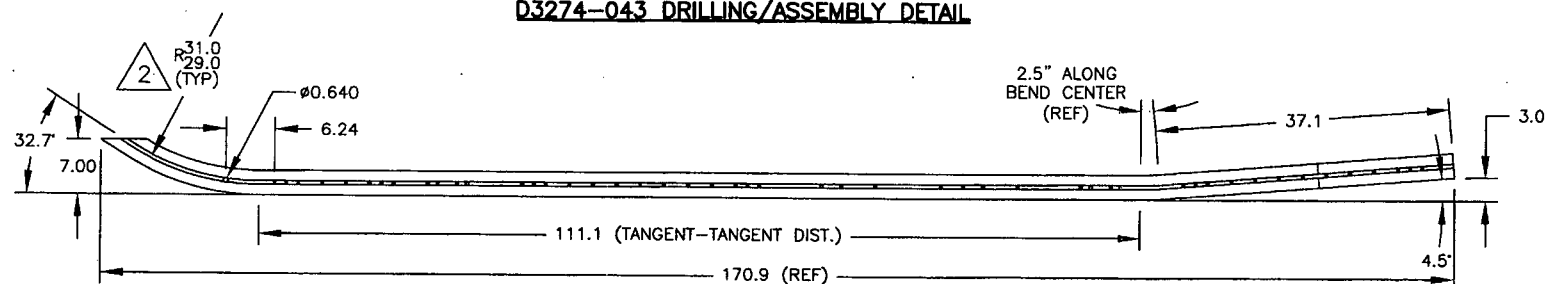
NOTE: Date & initial all entries

79015

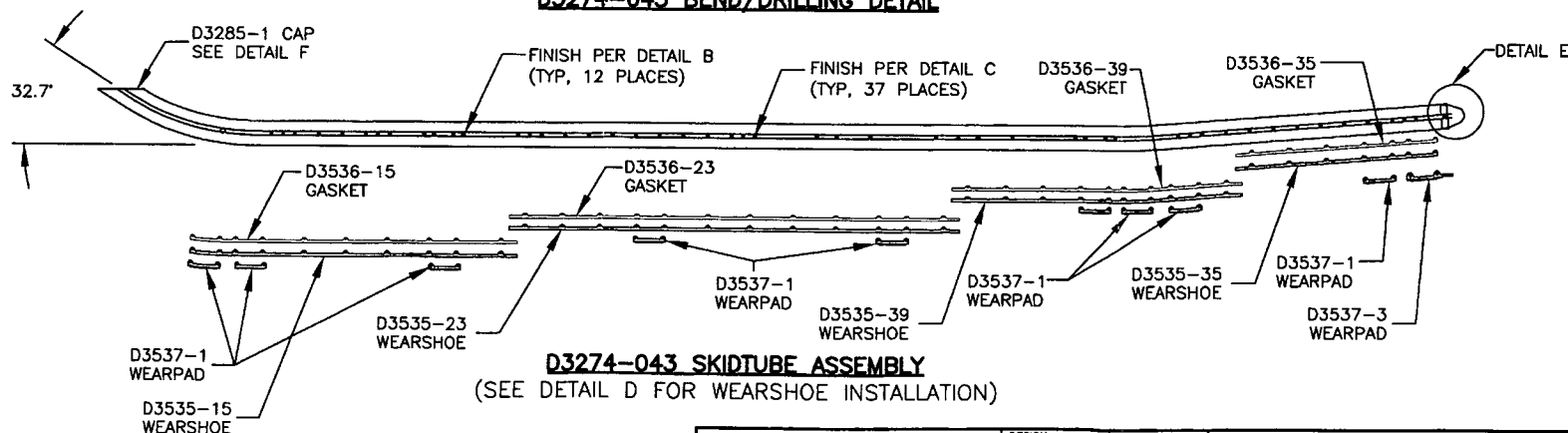
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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| | | | | |
|---------|----------|----------|-------------------|--|
| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED | H | APPROVED | H | DRAWING NO. D3274 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | REV. D SHEET 3 OF 4 SCALE 1:15 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

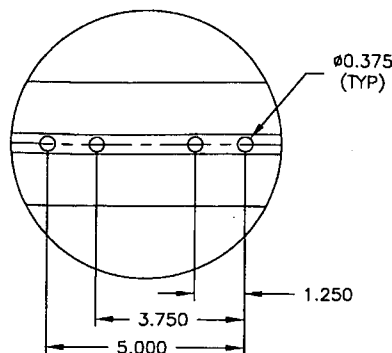
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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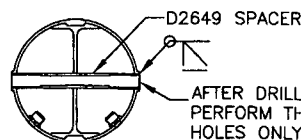
NOTE: Date & initial all entries

79015

DETAIL A: DRILL DETAIL

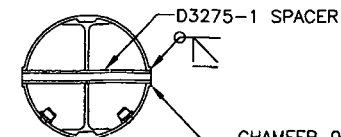


DETAIL B FOR $\phi 0.375$ HOLES ONLY



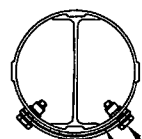
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$
HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO $\phi 0.313 \times 0.75$ DEEP

DETAIL C FOR $\phi 0.313$ HOLES ONLY



CHAMFER $0.030 \times 45^\circ$
(TYP)

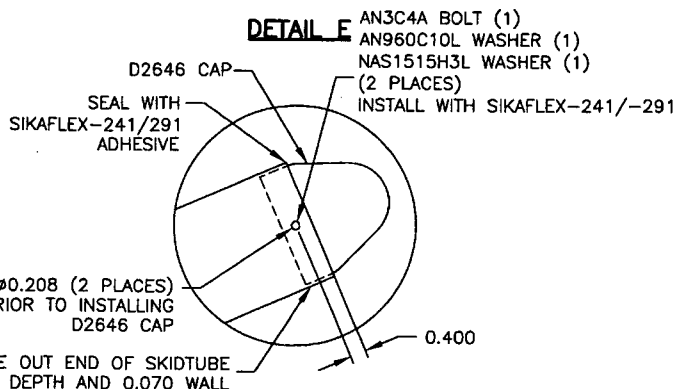
DETAIL D



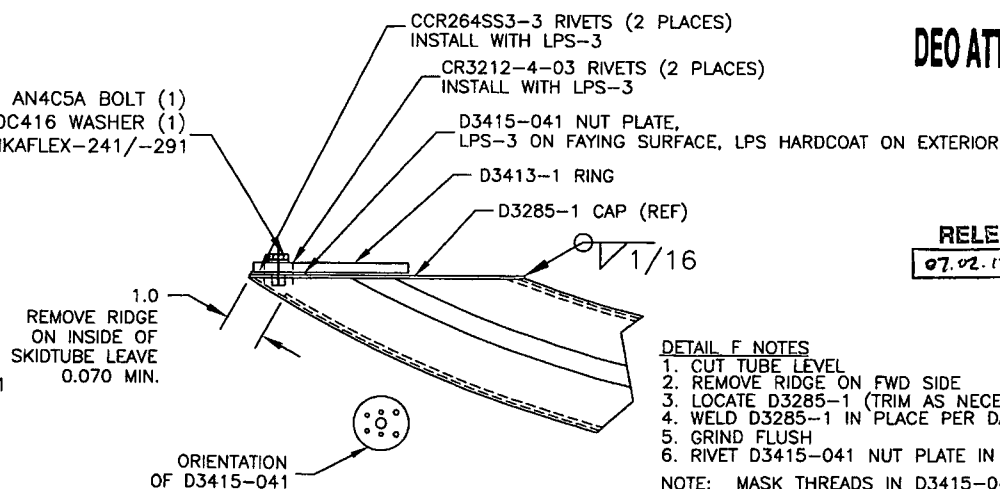
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED

07.02.12

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|------------------|----------------------------|--|
| DESIGN CP | DRAWN BY PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED H | APPROVED H | DRAWING NO. D3274 |
| DATE 06.12.19 | TITLE SKIDTUBE ASSEMBLY | REV. D SHEET 4 OF 4 SCALE 1:3 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

79015

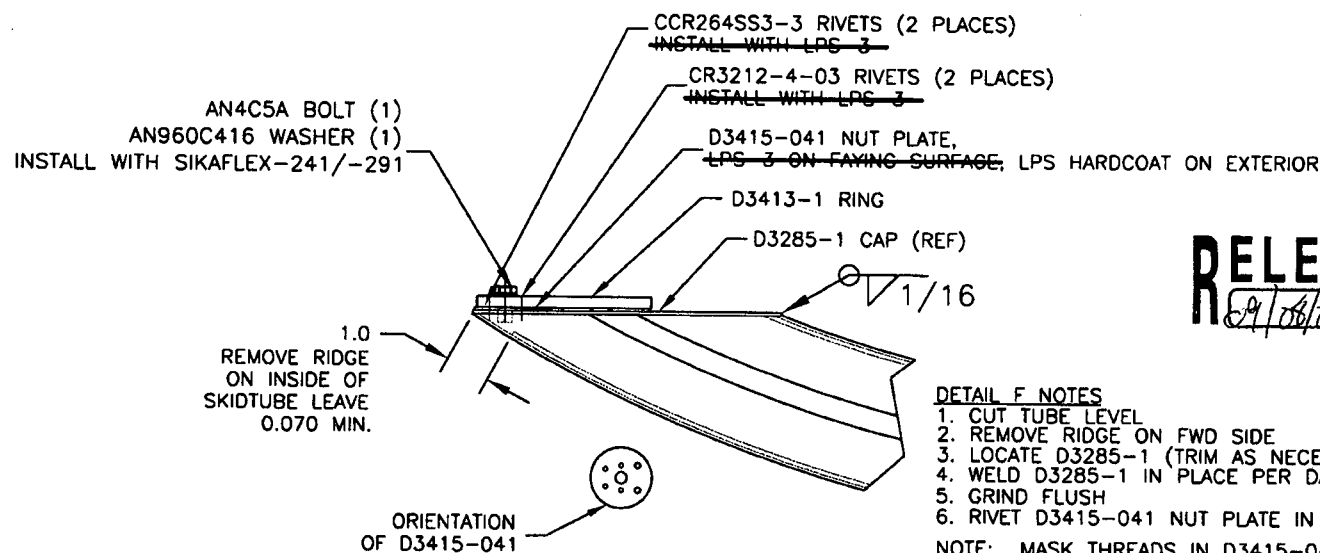
| | | | | | | | |
|----------------------|----------------------------|------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3274 | TITLE SKIDTUBE ASSEMBLY | REV. D | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3274-D-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN UP | CHECKED | MFG. APPR. | APPROVED | | DE APPR. | | |
| DATE 09.06.17 | DATE 09.06.23 | DATE 09/06/23 | DATE 09/06/23 | | DATE 09.06.23 | | |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

NO. 283

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 79243
Part number: A206-642-151
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Nural Date of Test Coupon 12.02.22

Welder Barclay Elliott Date of Test Coupon 12.02.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld